Claims

1. A pallet arrangement, preferably of the type intended for one-time use only, comprising an upper deck plate (2), bottom runners (3) and spacer elements (4) located between the deck plate (2) and the bottom runners (3) and functioning as pallet feet, said spacer elements (4) having the form of supportive tubular elements (5) and being fixed positionally in relation to the deck plate (2) against locking flaps (8) folded out from circular fold lines (7) punched in said deck plate (2), through the medium of the inner cylindrical surface (6) of said tubular spacer element, said locking flaps (8) being in turn, clamped firmly between the tubular spacer elements (5) and locking tubes (10) pressed from above into openings (9) formed in the deck plate (2) by punching-out and folding down said locking flaps (8), **characterized in**

that the bottom runners (3) are comprised of top and bottom U-shaped pallet runners (13,14) which are joined together with their respective legs (18-21) facing towards each other at the same time as the legs (18,19) of the upper pallet runners extend over and are affixed to the legs (20,21) of the lower pallet runners; and in

that the upper pallet runners (13) include apertures (12) for coaction with the tubular spacer elements (5), the lower free ends (11) of which are affixed to the inner bottom surface (16) of the lower runners (14) with the aid of an adhesive (15).

2. A pallet arrangement according to Claim 1, **characterized in** that the locking flaps (8) have a length which enables the flaps to be clamped firmly between the inner barrel surface (6) of the tubular spacer elements (5) and the locking tubes (10) pressed into said tubular spacer elements (5).

3. A pallet arrangement according to Claim 2, **characterized in** that the length of the locking flaps (8) is slightly smaller than half the inner diameter of the tubular spacer elements (5) or corresponds to half of said diameter; and in that the length of the locking tubes (10) may vary and that the diameter of said tubes is slightly smaller than the inner diameter of the tubular spacer elements (5).

4. A pallet arrangement according to Claim 1, **characterized in** that the locking flaps (8) are sectorial in shape with the base of respective sectors forming the circumferential fold lines (7).

5. A pallet arrangement acoording to Claim 1, **characterized in** that the bottom edges (25) of respective locking tubes (10) are able to coact lockingly with flap formations (22) which project out from the packaging material placed on the pallet (1) and which are provided with locking hooks or barbs (23, 24), such as to hold the packaging material firmly in position on said pallet.

6. A pallet arrangement according to Claim 1, **characterized in** that the deck plate (2) is comprised of corrugated fibreboard that has a thickness of about 7 mm; and in that the tubular spacer elements (5), the locking tubes (10) and the bottom runners (3) are comprised of solid board.

7. A method of manufacturing a pallet, preferably a pallet for one-time use only comprising an upper deck plate (2), bottom runners (3), and spacer elements (4) located between the deck plate (2) and the bottom runners and functioning as pallet feet, **characterized by**, before mounting of the spacer elements (4) having the form of tubular spacer elements below the deck plate (2), the steps of punching in the deck plate (2) with the aid of punch knives apertures or openings (9) that present sectorial locking flaps (8) having respective outer,

circumferentially extending weakenings in the form of fold lines (7), folding the locking flaps (8) down along said fold lines (7) into abutment with the inner barrel surface (6) of respective tubular spacer elements (5) and fixing said flaps in abutment with said barrel surface (6) with the aid of locking tubes (10) that can be pressed down through the openings (9) punched in said deck, said locking flaps (8) affixing the position of respective tubular spacer elements (5) with the aid of said locking tubes (10), by glueing the bottom runners (3) firmly to the free ends (11) of the tubular spacer elements (5).